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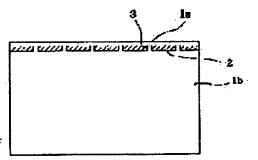
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(54) COMPOSITE INJECTION MOLDED ARTICLE

(57)Abstract:

PROBLEM TO BE SOLVED: To obtain strong integration force between a resin and an insert material, to be free from wrinkles and breakage, to have electromagnetic wave shielding properties, and to enable threedimensional molding by covering part of the cloth surface of an insert material with a thermoplastic resin continuous with a thermoplastic resin on the back side through the meshes of the cloth.

SOLUTION: On the surface side of the cloth 2 of a sheet of insert material such as a cotton nobinder nonwoven fabric having nearly equal elongation multidirectionally and heat resistance, a low melting point metal material which can be melted during the heating of a mold as a conductive material is stuck continuously and arranged in the mold. A molten thermoplastic resin 1b is injected/packed from the back side of the cloth 2, heated with the cloth 2 pressed to the inner surface of the mold, pushed out to the surface side through the meshes 3 of the cloth 2 to cover the surface partially or



entirely, cooled, and integrated mechanically with the cloth 2. In this way, the cloth 2 can be molded along a three-dimensional shape without generating peeling, wrinkles, and breakage to be an article having high electromagnetic wave shielding properties.

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